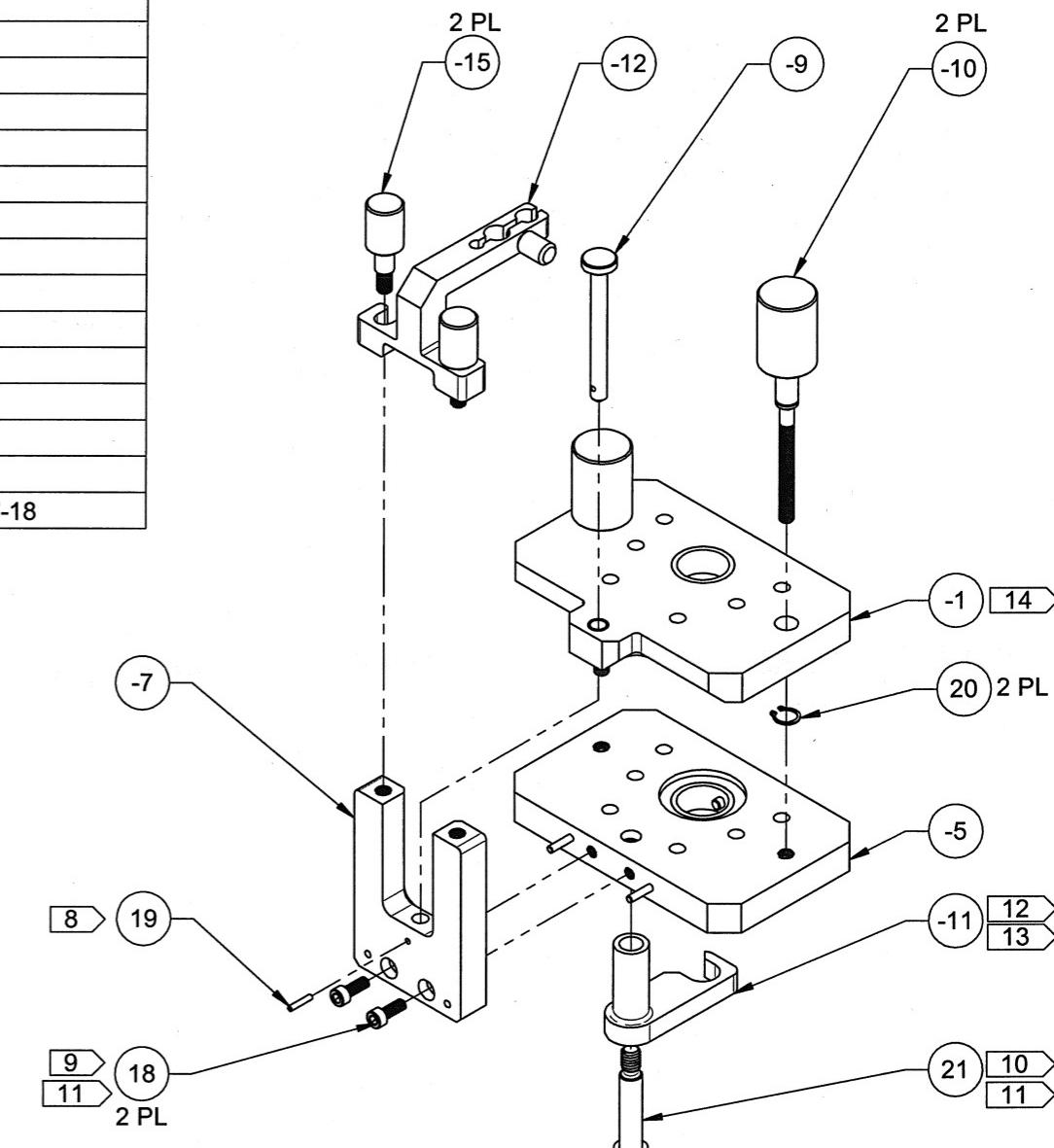
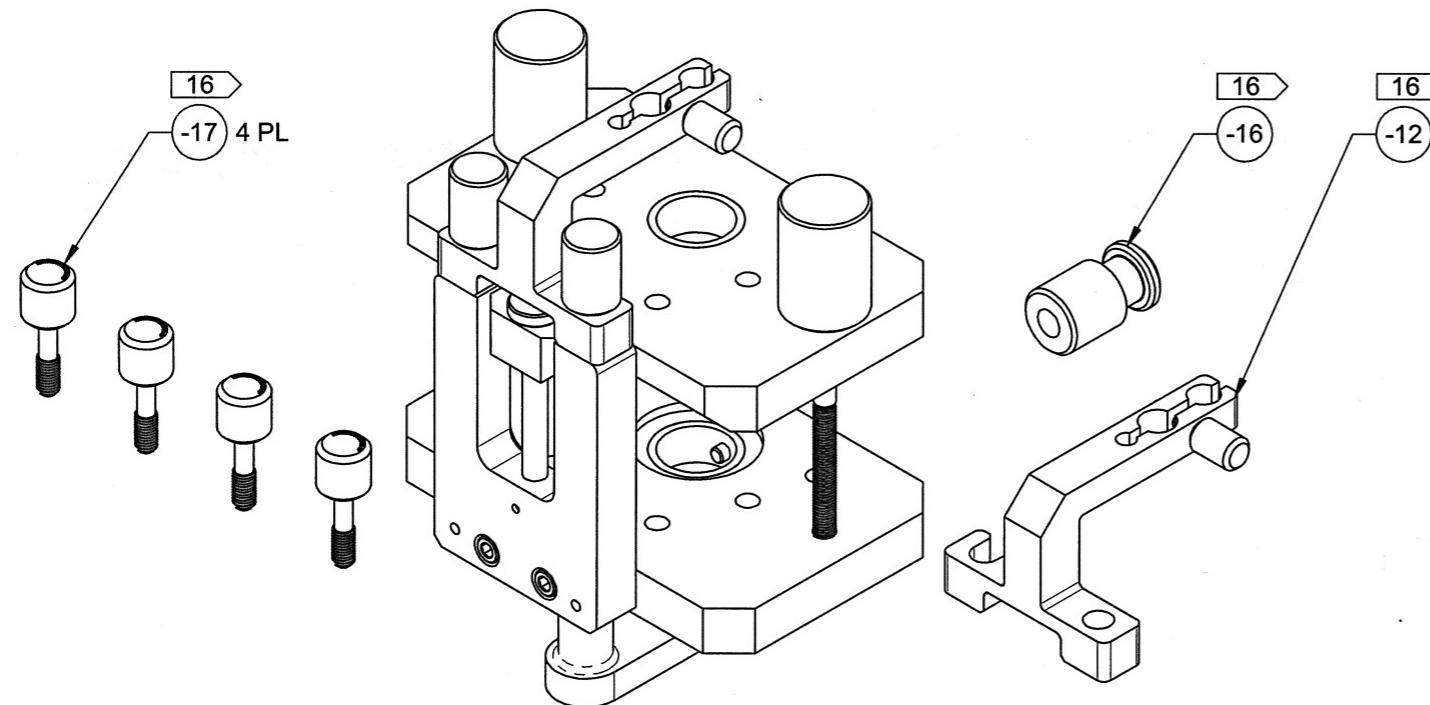


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6000G01732-6F-1	TOP PLATE ASSY
-5	1	RBW6000G01732-6F-5	BOTTOM PLATE ASSY
-7	1	RBW6000G01732-6F-7	SIDE PLATE ASSY
-9	1	RBW6000G01732-6F-9	ALIGNMENT PIN
-10	2	RBW6000G01732-6F-10	ADJUSTABLE PIN
-11	1	RBW6000G01732-6F-11	HOOK
-12	2	RBW6000G01732-6F-12	CLAMP ASSY
-15	2	RBW6000G01732-6F-15	ROTATION CLAMP PIN
-16	1	RBW6000G01732-6F-16	SPACER
-17	4	RBW6000G01732-6F-17	HOLE PIN
18	2	NAS1351-3-8P	CAD PLATED STEEL SOCKET HEAD SCREW #10-32 X 1/2" LG.
19	1	MS16555-320	PHOSPHATE PLATED STEEL DOWEL PIN 3/32" DIA. X 1/2" LG.
20	2	MS16624-1037	CAD PLATED STEEL EXTERNAL RETAINING RING FOR 3/8" OD
21	1	MS51576-36	STEEL SHOULDER SCREW 3/8" SHOULDER DIA. X 1-1/2" SHOULDER LENGTH X 5/16"-18



TOOL ASSY WITHOUT SPARE PARTS

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 19 WITH ITEM -9, AND REMOVE EXCESS

9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 18 THEN ASSEMBLE WITH ITEM -5, AND REMOVE EXCESS

10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 21 THEN ASSEMBLE WITH ITEM -5, AND REMOVE EXCESS

11) INSTALL ITEM 18 AND ITEM 21 HAND TIGHT

12) ITEM -11 MUST ROTATE FREELY

13) ITEM -11 MUST BE CONCENTRIC WITH ITEM -5, ITEM -1 AND ITEM -12 HOLES WHEN ENGAGED

14) ITEM -1 MUST SLIDE FREELY INTO ITEM -7

15) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

16) SPARE PARTS MUST BE PACKAGED INDIVIDUALLY WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-862	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	FK	RBW6000G01732-6F	
APPROVED	(initials)	REV. A	
DATE 2019-08-16		SHEET 1 OF 19	
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS	
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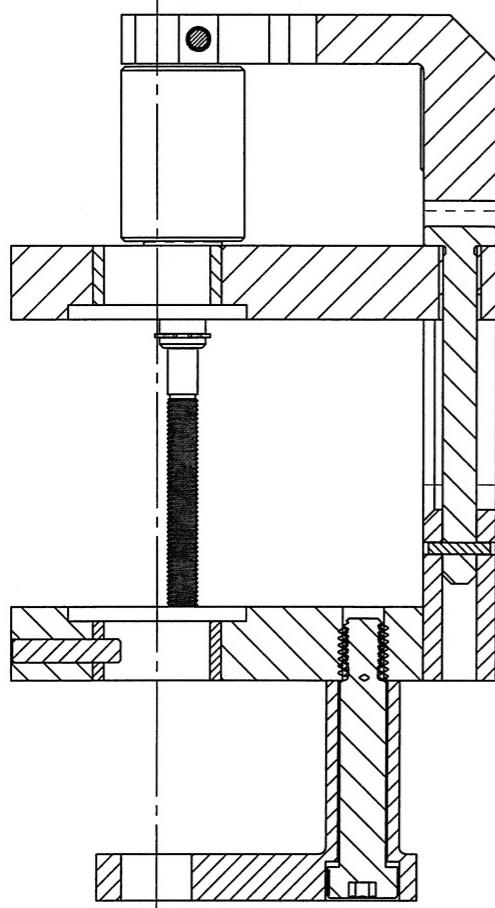
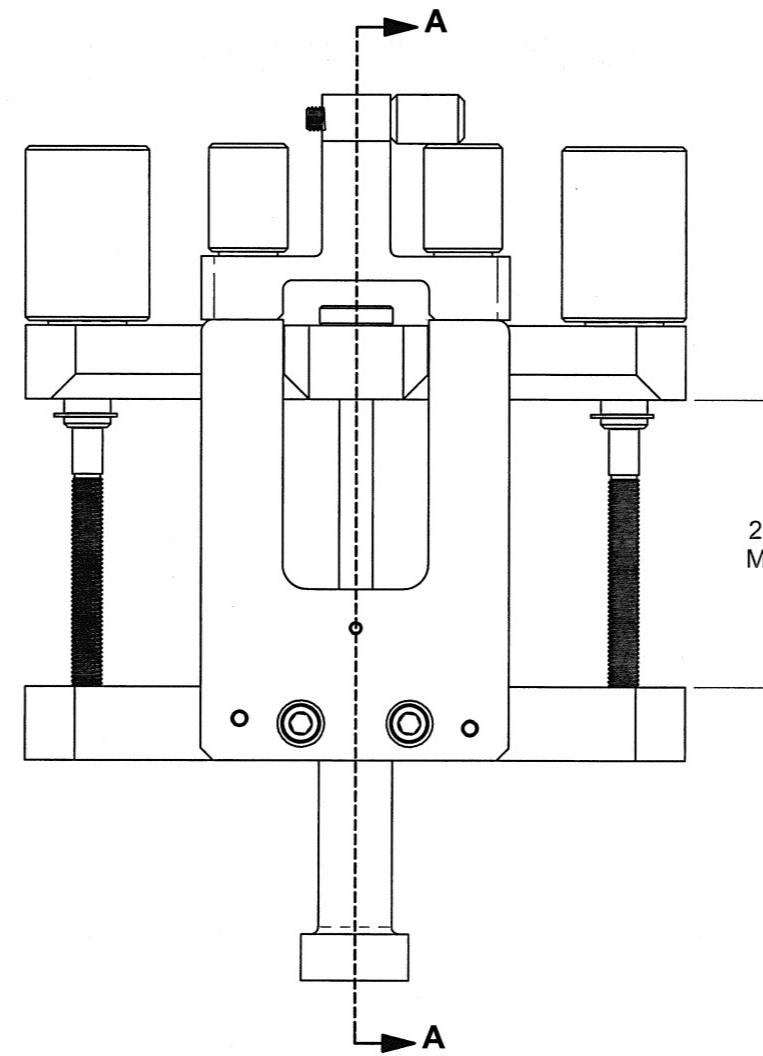
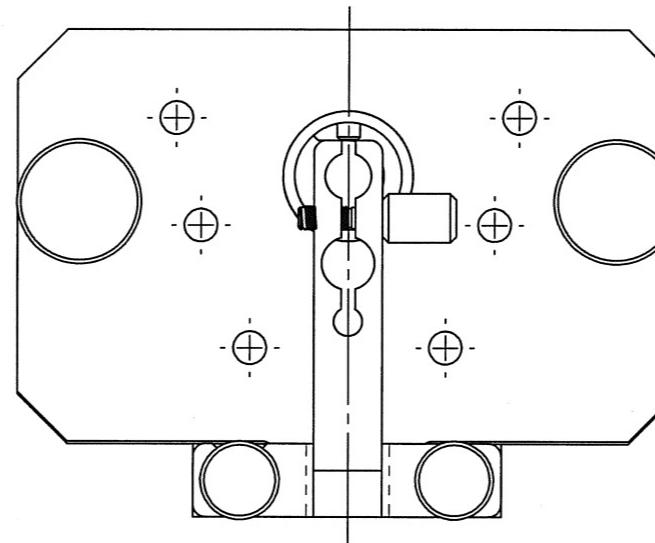
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**SECTION A-A**

DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	FK
APPROVED	WJ

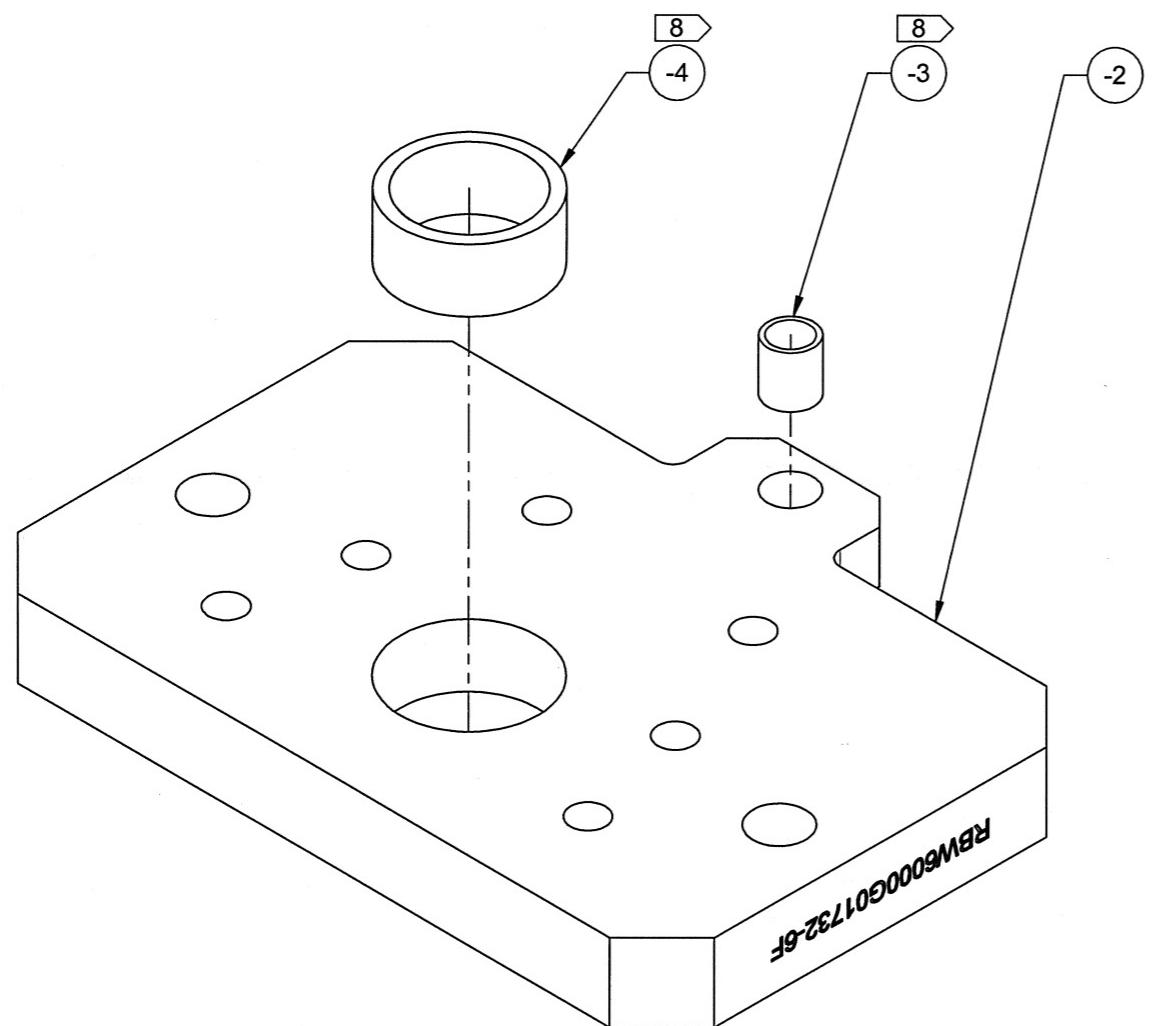
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # **RBW6000G01732-6F** REV. A
TITLE **AXIAL PLAY CHECK TOOL** SHEET 2 OF 19
DATE **2019-08-16**

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ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6000G01732-6F-2	TOP PLATE
-3	1	RBW6000G01732-6F-3	PIN BUSHING
-4	1	RBW6000G01732-6F-4	ALIGNMENT BUSHING

D

**RBW6000G01732-6F-1 TOP PLATE ASSY****NOTES:**

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

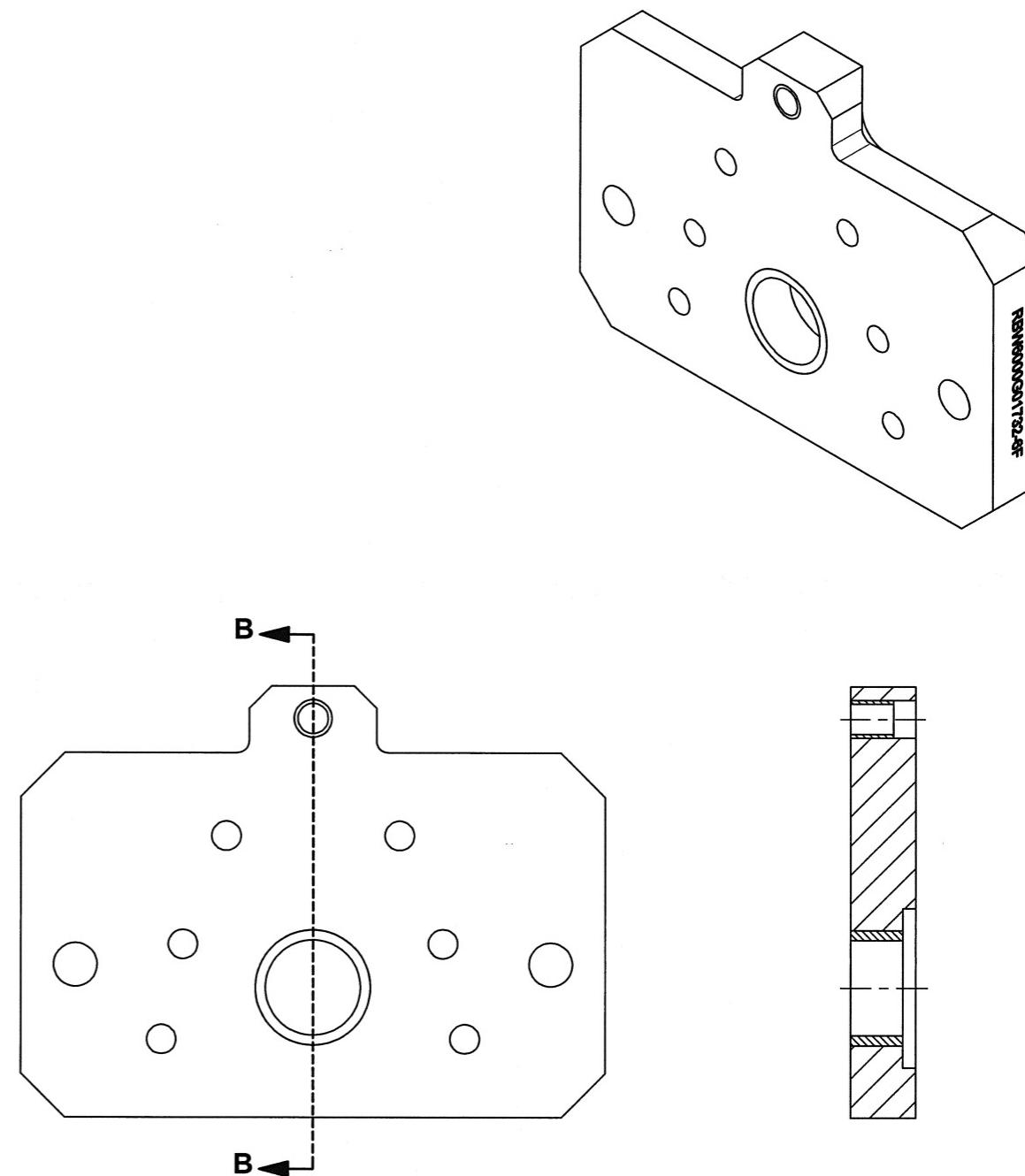
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -3 AND ITEM -4 FLUSH TO SURFACE OF ITEM -2 AS SHOWN, AND REMOVE EXCESS

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**SECTION B-B**

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G01732-6F
APPROVED	WP	REV. A

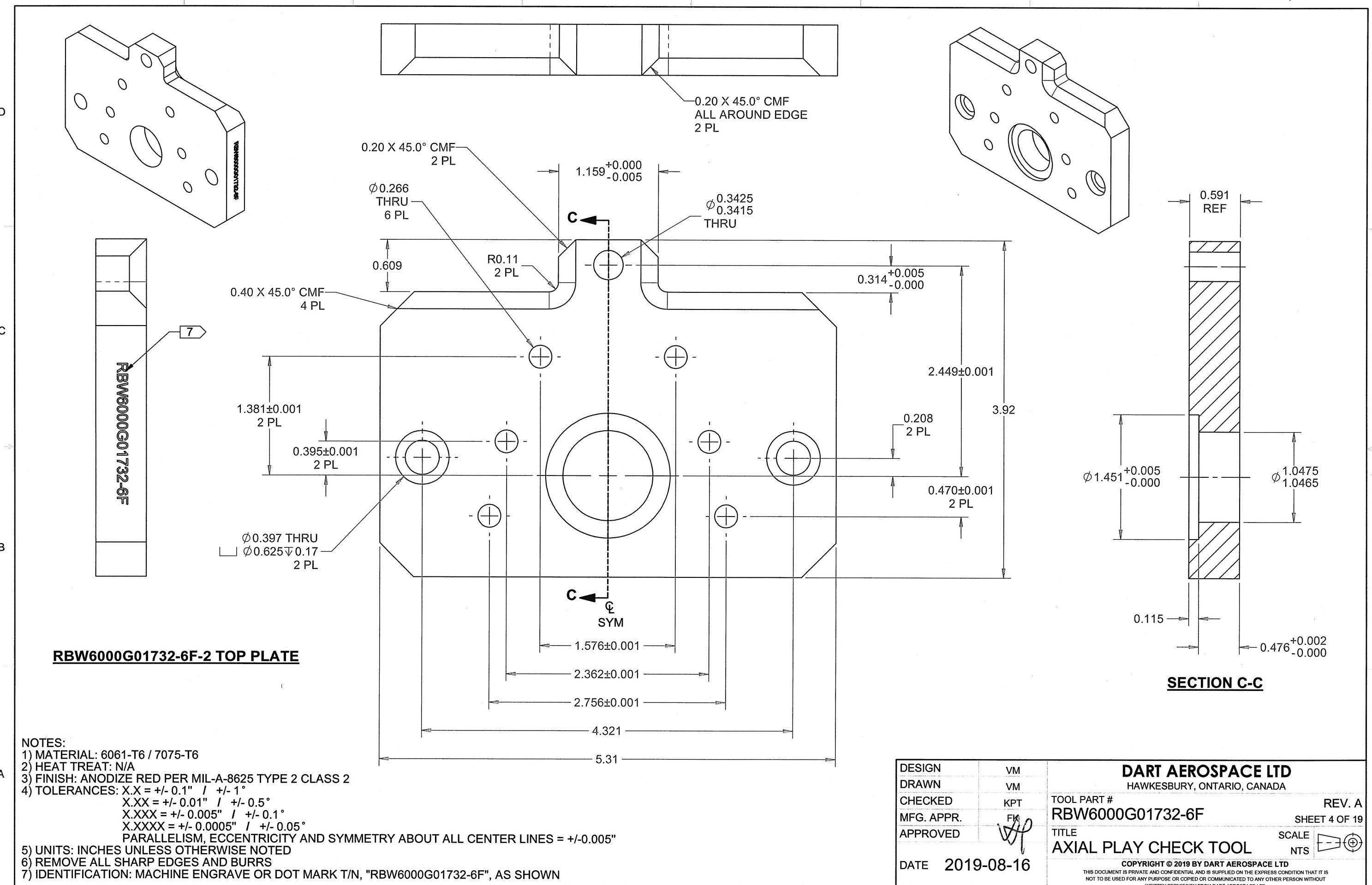
DATE 2019-08-16

SHEET 3 OF 19

SCALE NTS

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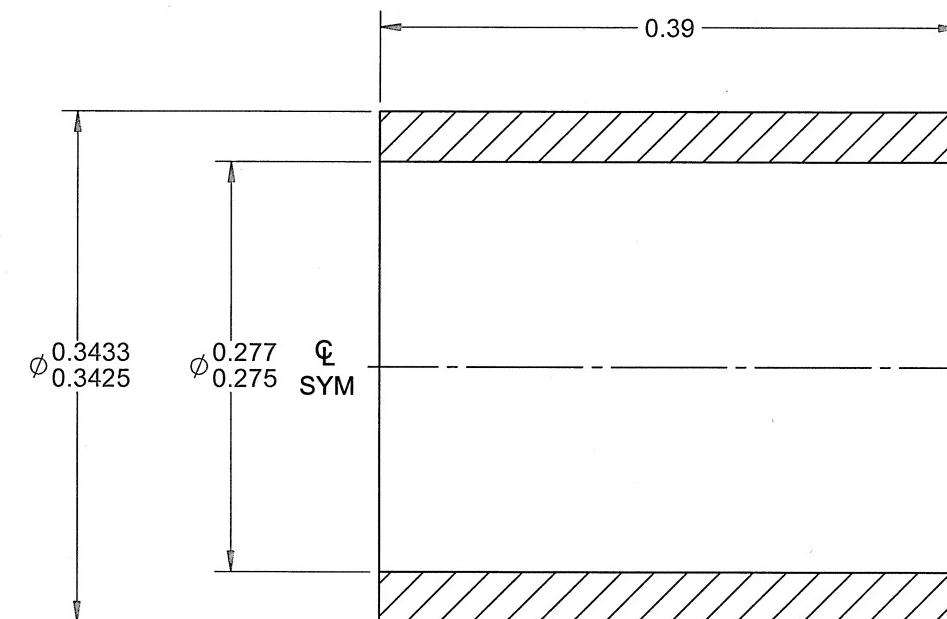
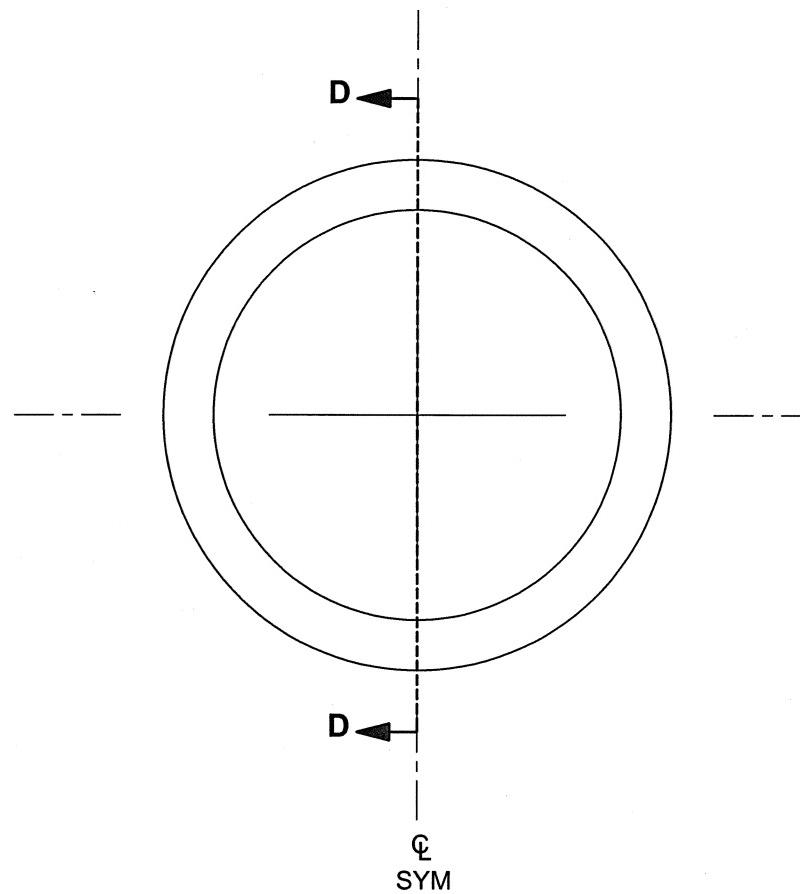
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SECTION D-D

RBW6000G01732-6F-3 PIN BUSHING

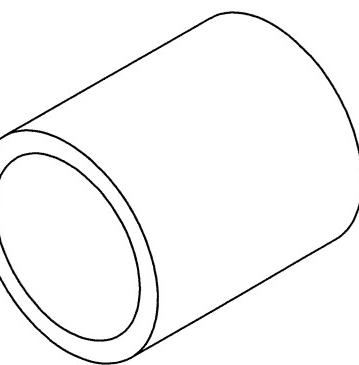
NOTES:

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6000G01732-6F	SHEET 5 OF 19
APPROVED	WP	TITLE	AXIAL PLAY CHECK TOOL
DATE 2019-08-16		SCALE	NTS

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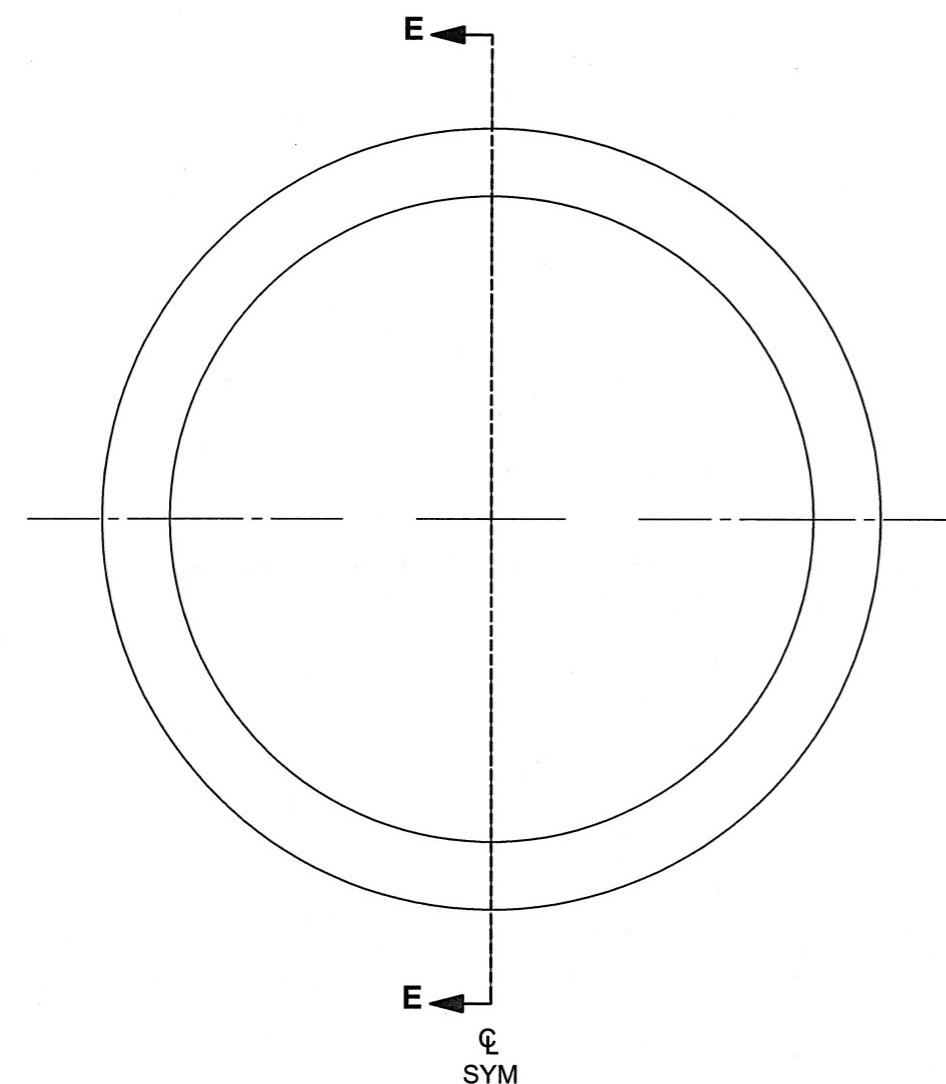
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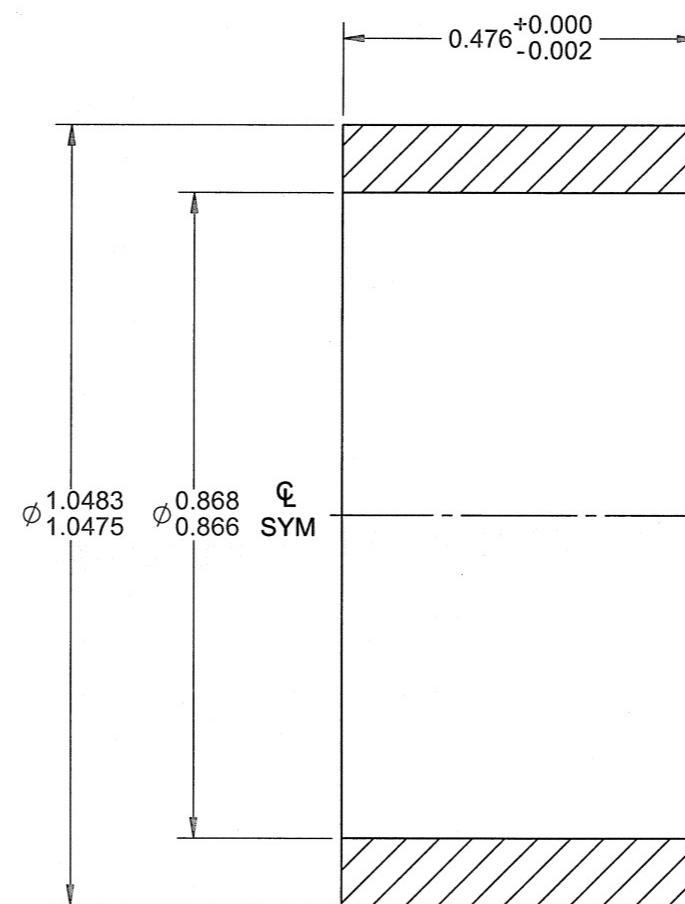
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RBW6000G01732-6F-4 ALIGNMENT BUSHING



SECTION E-E

NOTES:

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6000G01732-6F	SHEET 6 OF 19
APPROVED	<i>[Signature]</i>	TITLE	AXIAL PLAY CHECK TOOL
DATE 2019-08-16		SCALE NTS	

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ITEM #	QTY	PART #	PART TITLE
-4	1	RBW6000G01732-6F-4	ALIGNMENT BUSHING
-6	1	RBW6000G01732-6F-6	BOTTOM PLATE
22	1	MS16555-342	PHOSPHATE COATED STEEL DOWEL PIN 3/16" DIA. X 7/8" LG.
23	2	MS16555-329	PHOSPHATE COATED STEEL DOWEL PIN 1/8" DIA. X 3/4" LG.
24	2	MS21209-F4-20P	CAD PLATE SS HELICAL INSERT 1/4"-28 X 1/2" LG.
25	1	MS21209-C51-5P	CAD PLATED SS HELICAL INSERT 5/16"-18 X 0.469" LG.
26	2	MS21209-F1-25P	CAD PLATE SS HELICAL INSERT #10-32 X 0.475" LG.

The diagram shows a horizontal beam supported by two vertical columns. The left column has a circular top and is labeled 'G'. The right column is labeled 'F' at the top and '0.353±0.002' with a small box containing the number '9' at the bottom right. A vertical dashed line extends from the center of the left column through the beam to the right column. Two upward-pointing arrows labeled 'F' are positioned on the beam, one near each support. A downward-pointing arrow is also present on the beam between the supports.

A technical drawing of a mechanical part. The part features a central vertical hole with a shoulder. Around this central feature are seven circular holes arranged in a pattern. The entire assembly is mounted on a base plate with diagonal hatching. Dimensioning includes a top dimension of $\phi 0.1875$ and 0.1865 with a leader pointing to the shoulder, and a side dimension of 0.730 with a leader pointing to the right edge of the base plate.

SECTION F-F

RBW6000G01732-6F-5 BOTTOM PLATE ASSY

NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

NCES: X.X = +/- 0.1" / +/- 1°

$$X_{\text{XX}} = +/- 0.01'' \quad / \quad +/- 0.$$

X-XX

$$X_{XXXX} = \pm 0.005'' \quad / \quad \pm 0.1^\circ$$

PARALLELISM ECCENTRICITY A

PARALLELISM, ECCENTRICITY AND
SOURCES UNLESS OTHERWISE NOTED

INCHES UNLESS OTHERWISE NOTED
LOCATION: N/A

CATION: N/A
E AS SHOWN

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RETAINING COMPOUND

THEN PRESS FIT ITEM -4 WITH ITEM -6, AND REMOVE EXCESS

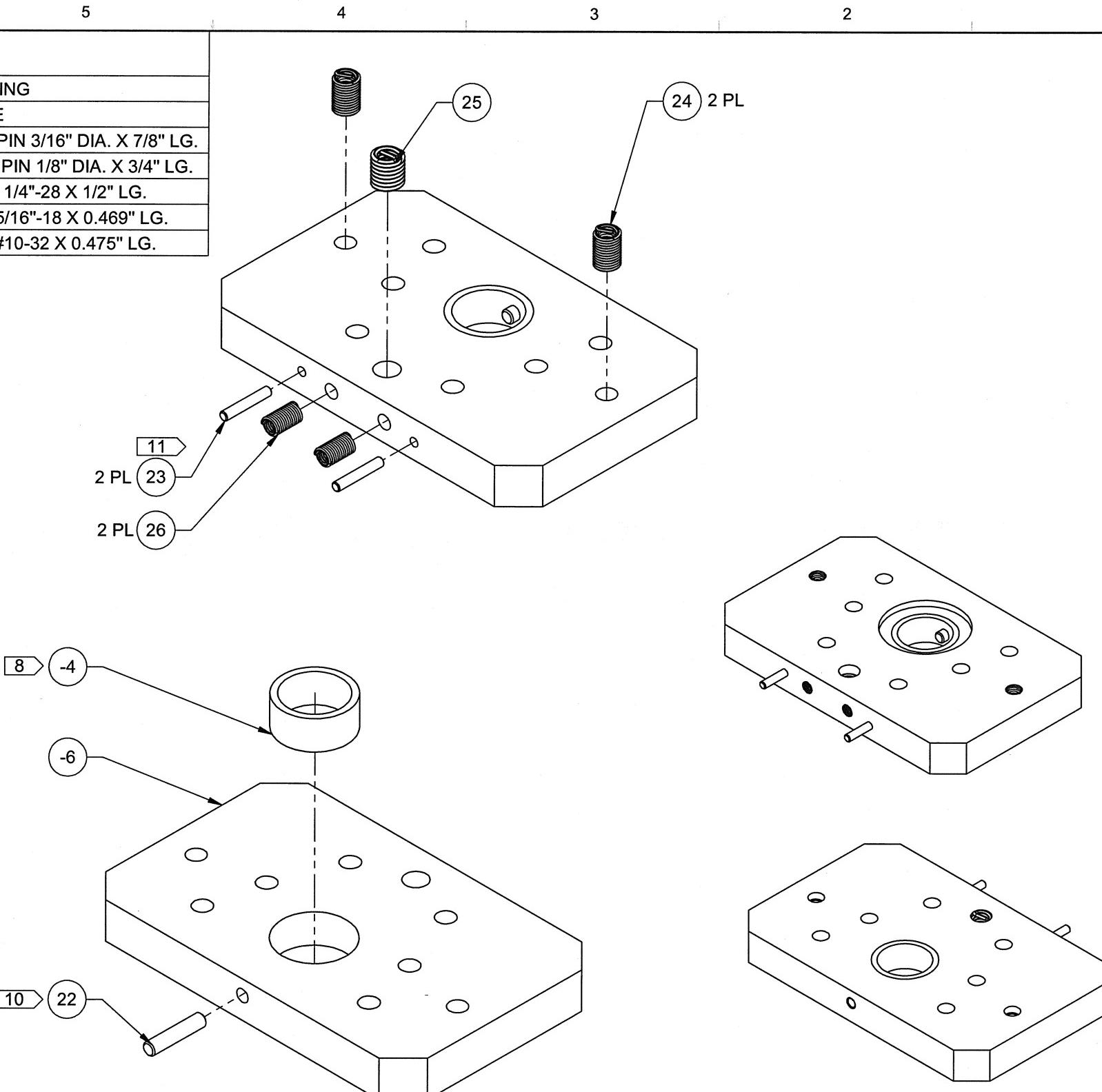
9) TRANSFER DRILL HOLE THROUGH ITEMS -6 AND -4 AS SHOWN

10) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT

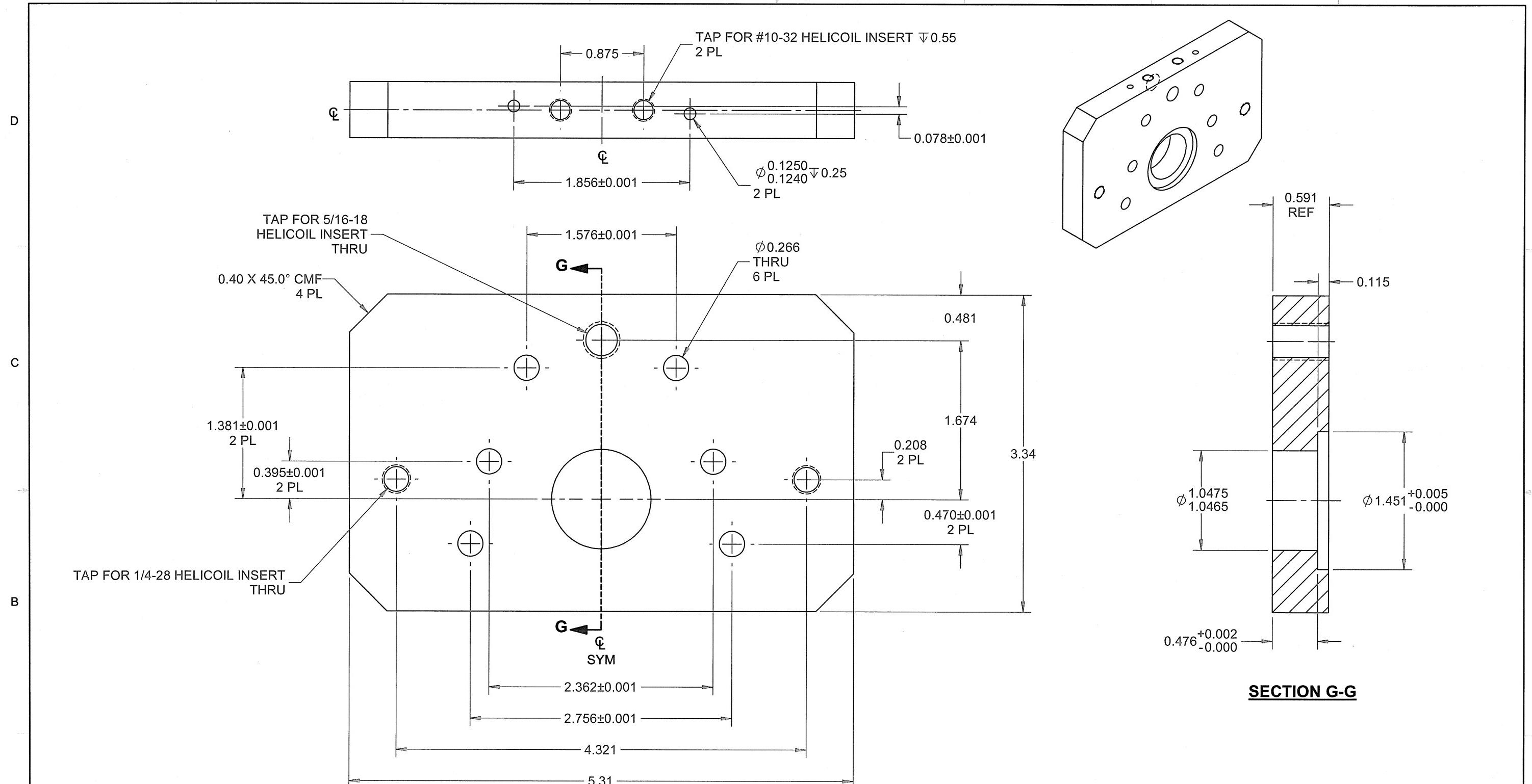
'THEN PRESS FIT ITEM 22 WITH ITEM -6, AND REMOVE EXCESS

11) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT

THEN PRESS FIT ITEM 23 WITH ITEM -6, AND REMOVE EXCESS



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	
MFG. APPR.	FK	SHEET 7 OF 19	
APPROVED	<i>VWP</i>	SCALE	
DATE	2019-08-16	NTS	
TOOL PART #		RBW6000G01732-6F	
TITLE		AXIAL PLAY CHECK TOOL	
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NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE PFD PER MIL-A-8625 TYPE 2 CLASS 1

3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS
4) TOLERANCES: X X = +/- 0.1" / +/- 1°

4) TOLERANCES: $\Delta x = \pm 0.1''$ / $\pm 0.01''$

$$X_{xx} = +/- 0.01'' \quad / \quad +/- 0.5''$$

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.0005"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005

6) REMOVE ALL SHARP EDGES AND BURRS.

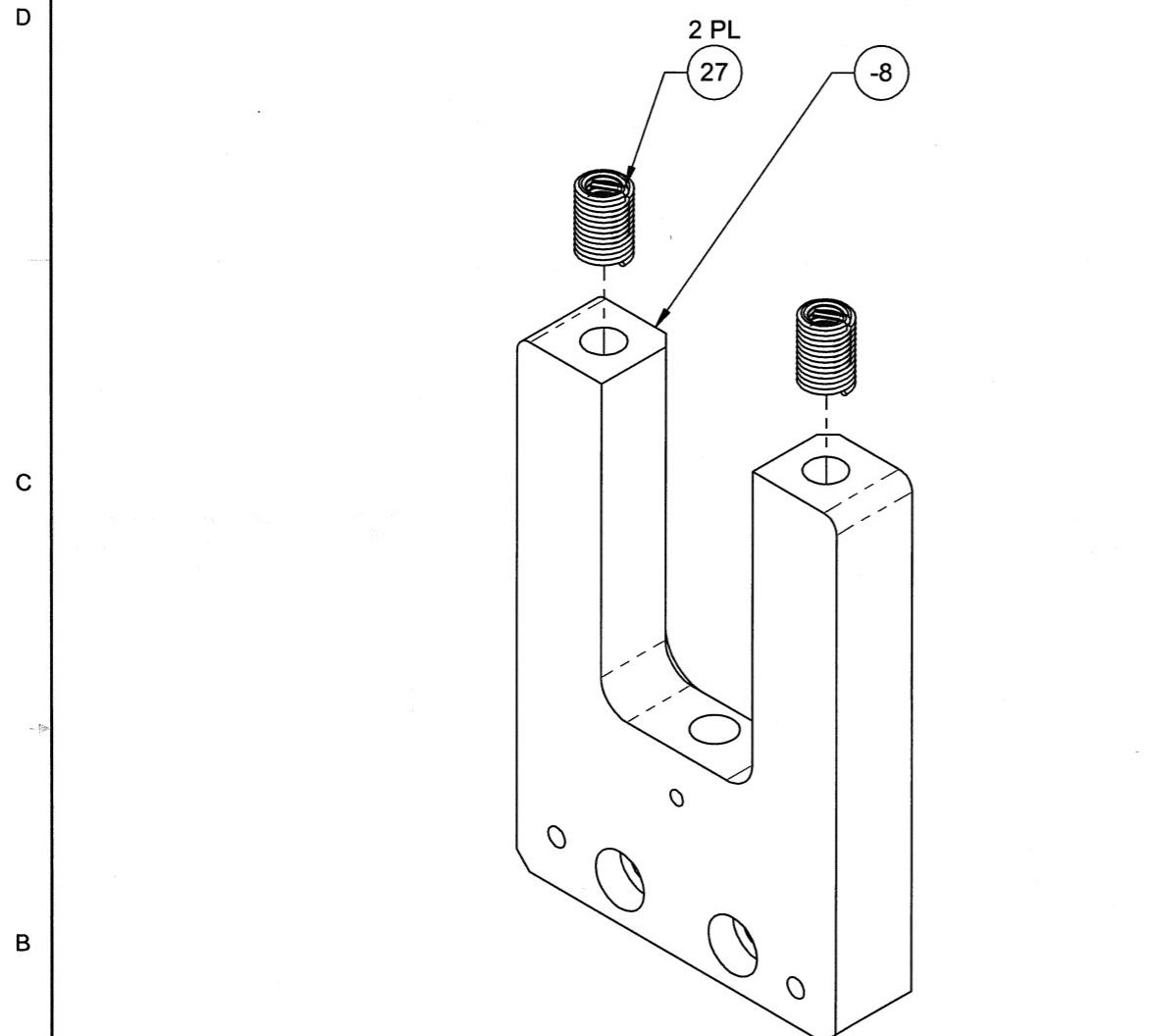
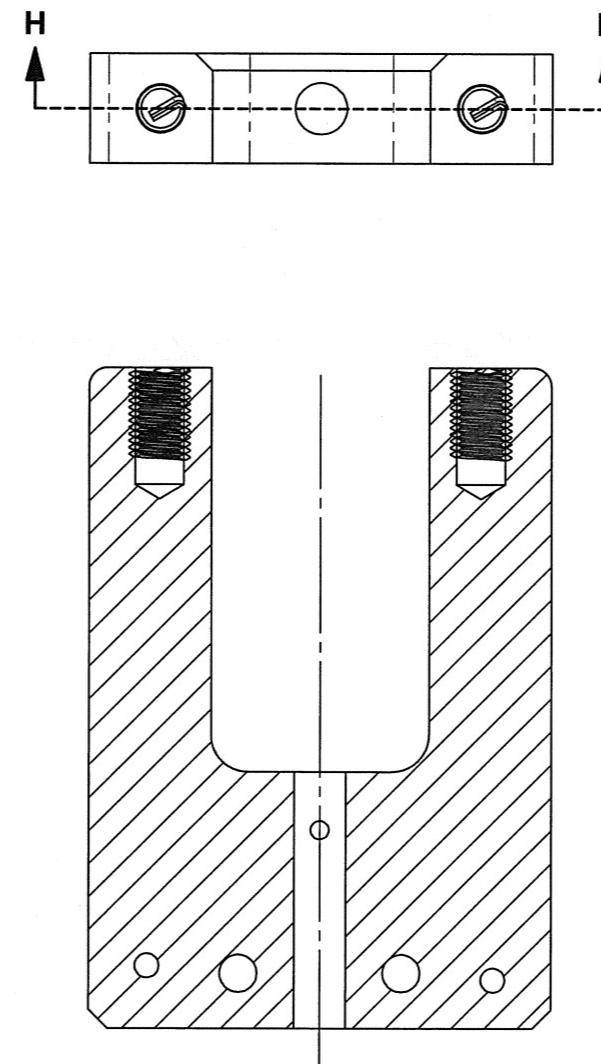
6) REMOVE ALL SHARP
7) IDENTIFICATION: N/A

RBW6000G01732-6F-6 BOTTOM PLATE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	
MFG. APPR.	FK	SHEET 8 OF 19	
APPROVED	<i>WP</i>	SCALE	NTS
DATE	2019-08-16	AXIAL PLAY CHECK TOOL	
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ITEM #	QTY	PART #	PART TITLE
-8	1	RBW6000G01732-6F-8	SIDE PLATE
27	2	MS21209-F4-20P	CAD PLATE SS HELICAL INSERT 1/4"-28 X 1/2" LG.

**RBW6000G01732-6F-7 SIDE PLATE ASSY**

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	
MFG. APPR.	FK	TOOL PART #	
APPROVED	WP	RBW6000G01732-6F	
DATE 2019-08-16		SHEET 9 OF 19	
TITLE AXIAL PLAY CHECK TOOL			
SCALE NTS			
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TAP FOR 1/4-28 HELICOIL 70.
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— 0.09 X 45.0° CMF
ALL AROUND EDGE

Ψ 0.

0.280 THRI

φ 0.277 mrc

This technical drawing shows a cross-sectional view of a mechanical part. The overall height is 3.54. A vertical dimension of 0.769 is shown from the bottom to a horizontal line. A horizontal dimension of 1.856 ± 0.001 is shown across the top. A central feature has a diameter of Ø 0.201 THRU ALL layers, with a note for Ø 0.375 and a depth of 0.19. Two thru-holes are located at a height of 0.312 from the bottom line, with a diameter of Ø 0.130 ± 0.002 and a note for 2 PL. A small hole is located at a height of 0.806 from the bottom line. A vertical dimension of 0.078 is shown from the bottom to a horizontal line. A horizontal dimension of 0.10 X 4 is shown across the top. A note indicates R0.10 2 PL for the top right corner. A note indicates R0.20 2 PL for the top left corner. A note indicates 1.171 +0.005 -0.000 for the top width.

A technical line drawing showing a U-shaped metal bracket assembly. The bracket consists of two vertical legs meeting at a central horizontal U-joint. A horizontal slot is cut into the inner side of each leg, intersecting the U-joint. A small circular hole is located at the top of each vertical leg. The drawing uses solid lines for major features and dashed lines for hidden features like the slot boundaries.

RBW6000G01732-6F-8 SIDE PLATE

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	SHEET 10 OF 19
MFG. APPR.	FK		
APPROVED	<i>WP</i>		
DATE	2019-08-16	SCALE	NTS
TOOL PART #		RBW6000G01732-6F	
TITLE		AXIAL PLAY CHECK TOOL	
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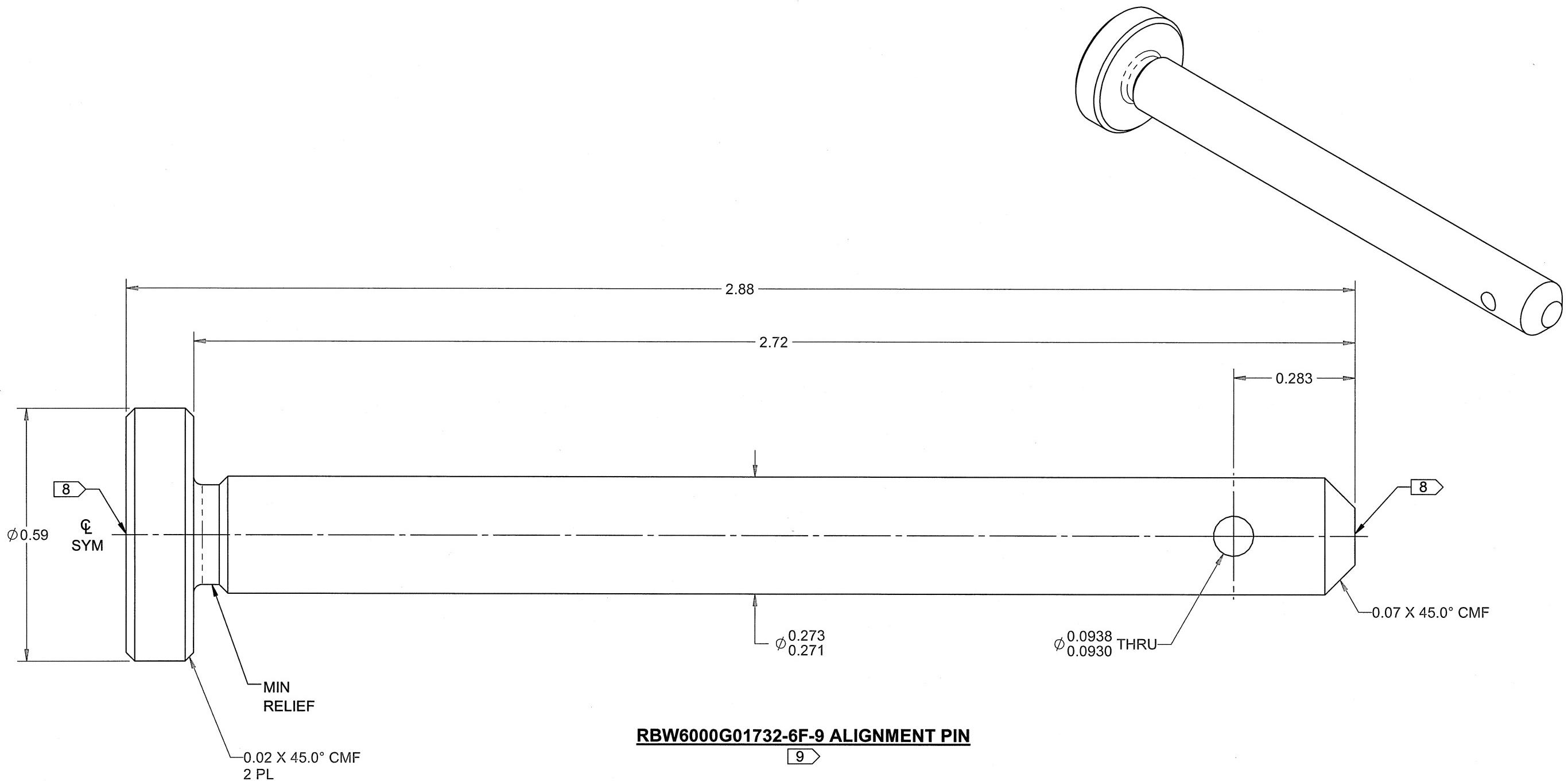
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**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE
- 9) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	FK	
APPROVED	WF	
DATE 2019-08-16		REV. A
TOOL PART # RBW6000G01732-6F		SHEET 11 OF 19
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS
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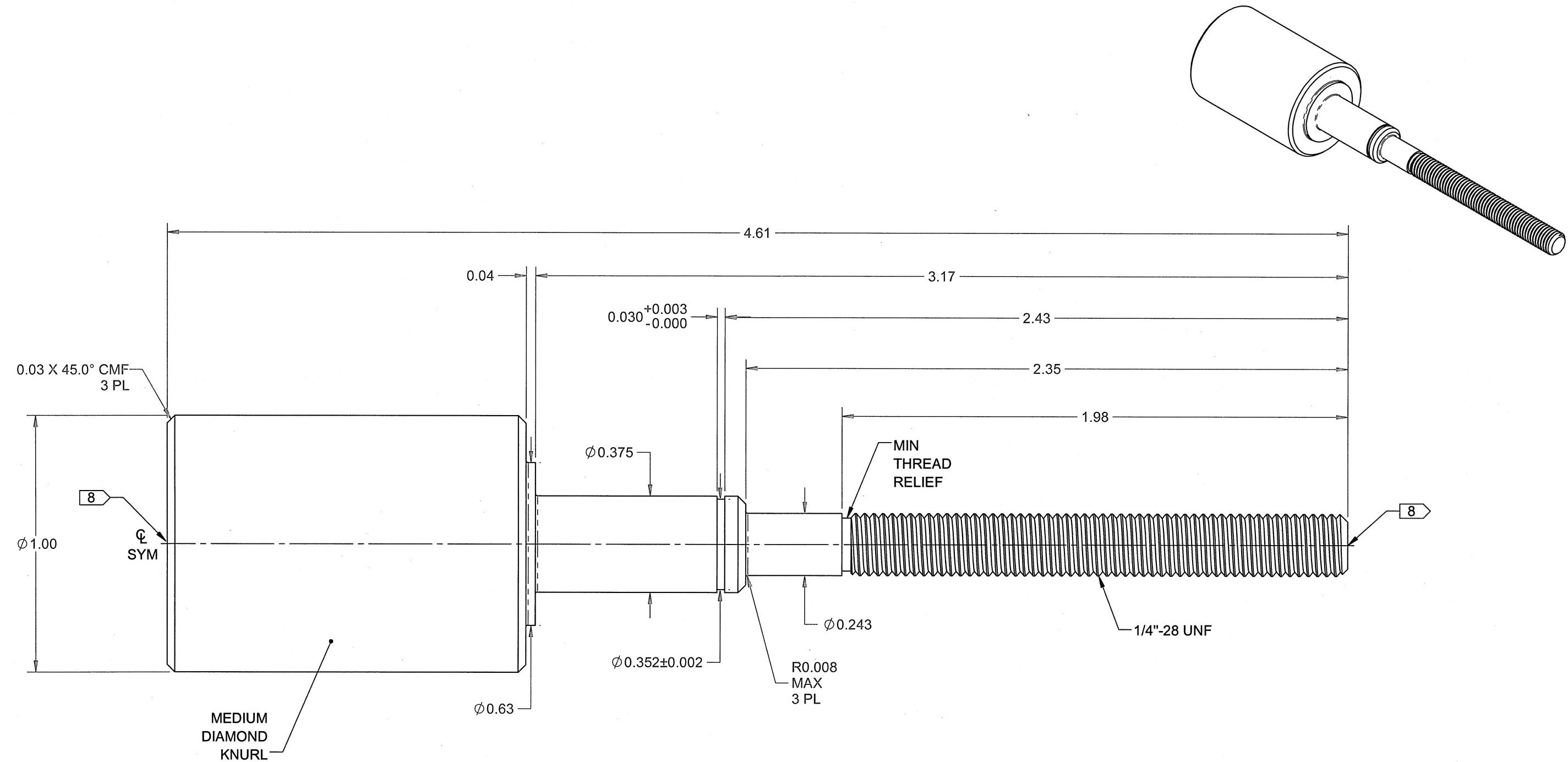
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RBW6000G01732-6F-10 ADJUSTABLE PIN

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

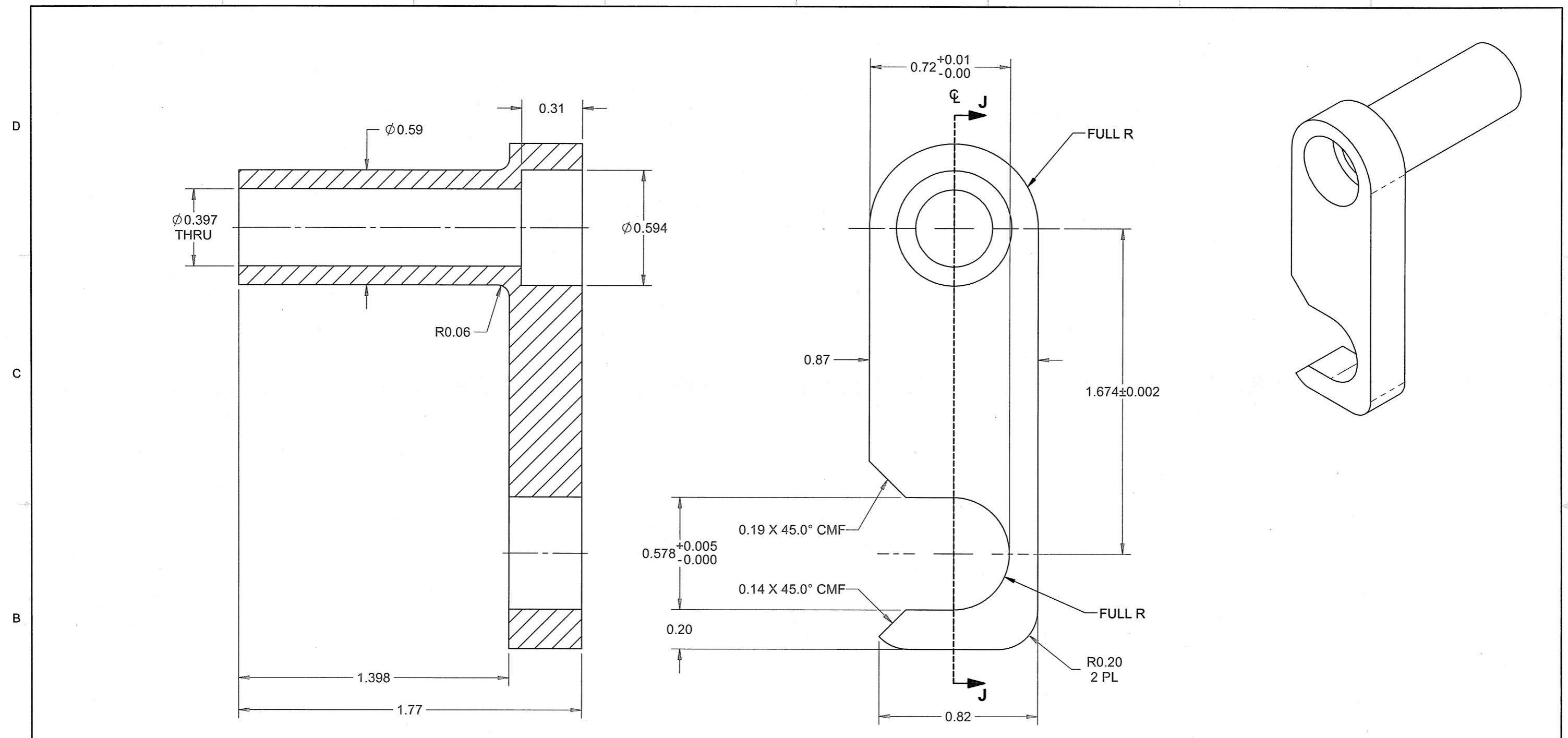
DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G01732-6F
APPROVED	VWP	REV. A

DATE 2019-08-16

SCALE NTS

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SECTION J-JRBW6000G01732-6F-11 HOOK

8

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	WP		
DATE 2019-08-16		REV. A	
TOOL PART # RBW6000G01732-6F		SHEET 13 OF 19	
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS	

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ITEM #	QTY	PART #	PART TITLE
-13	1	RBW6000G01732-6F-13	CLAMP
-14	1	RBW6000G01732-6F-14	CLAMP PIN

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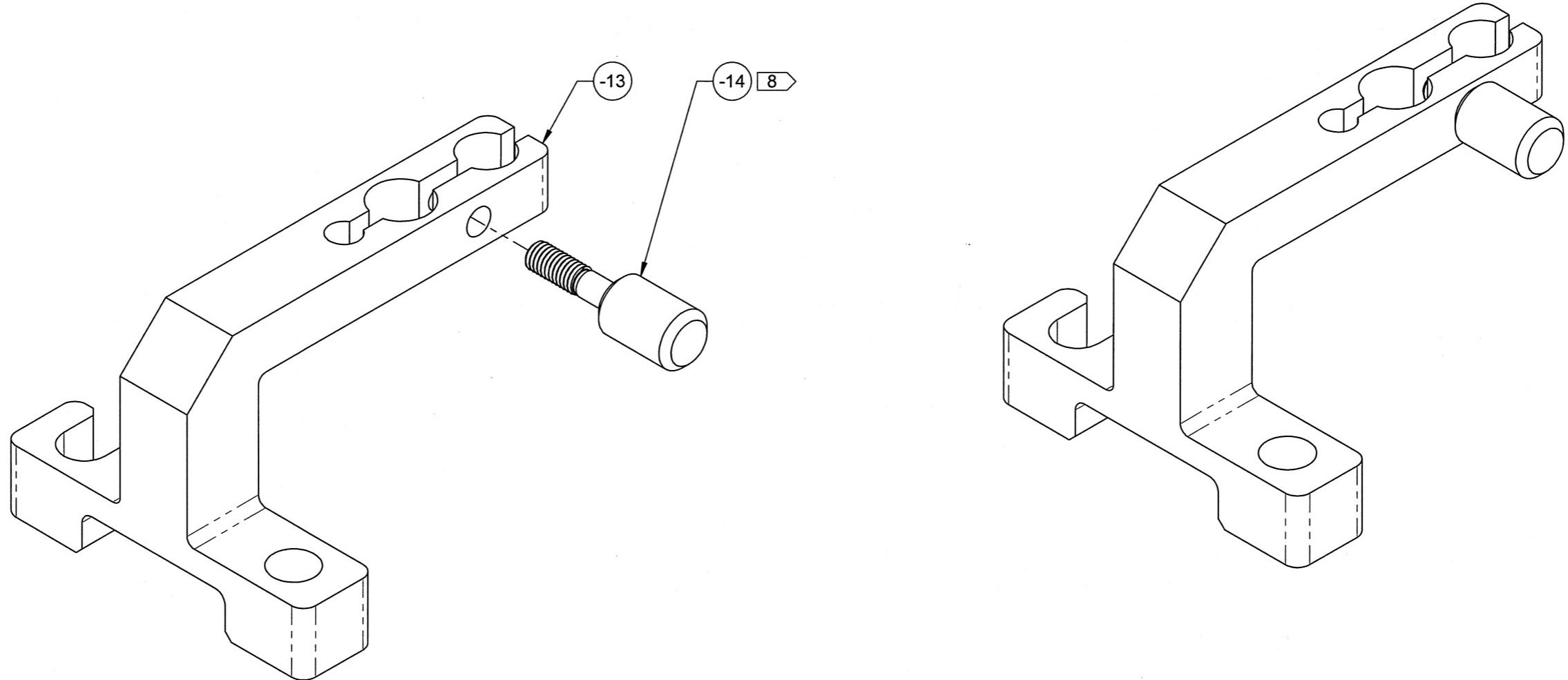
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RBW6000G01732-6F-12 CLAMP ASSY

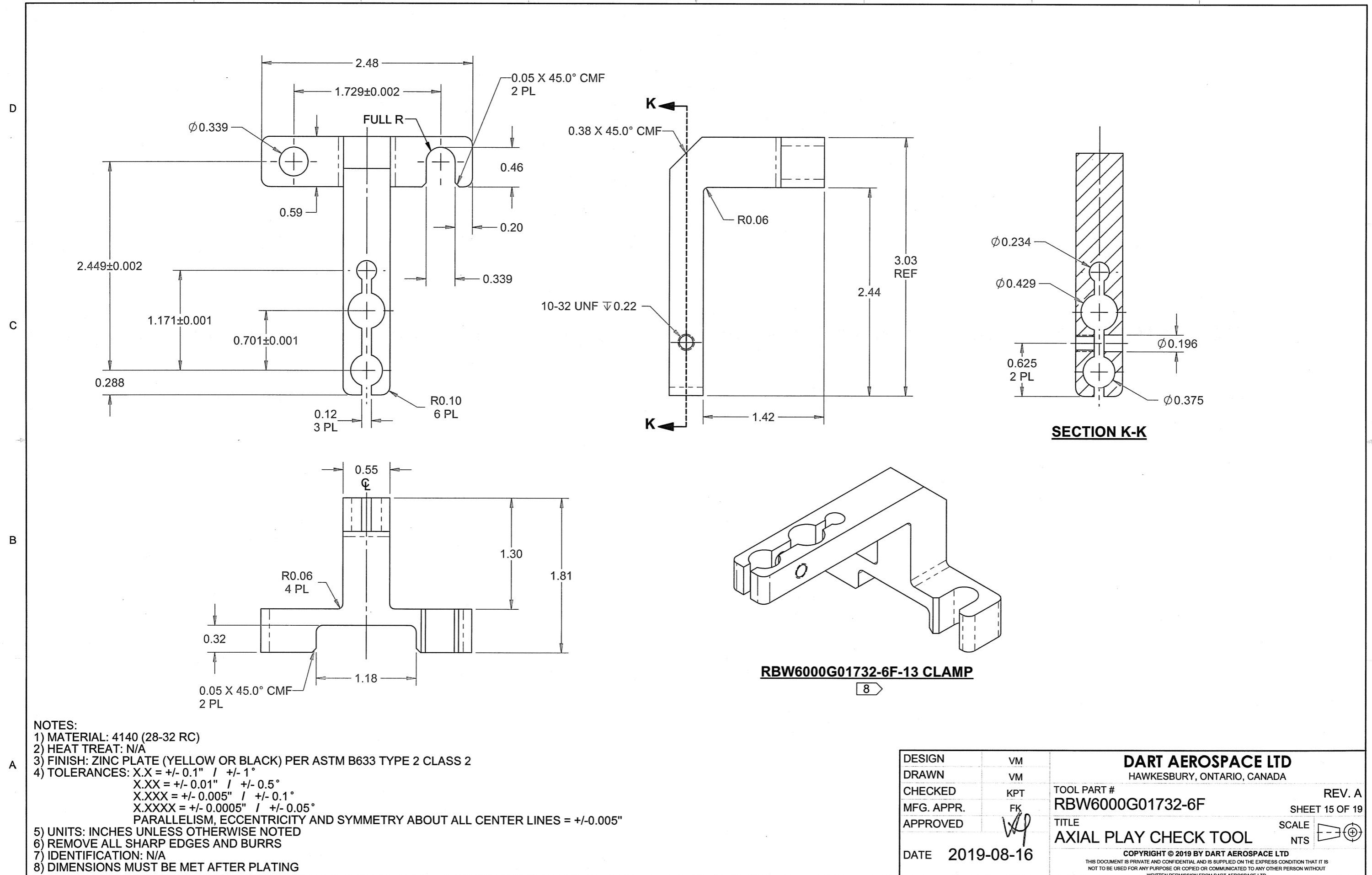
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM -14 HAND TIGHT

DESIGN DRAWN	VM VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV. A
APPROVED	VJ	RBW6000G01732-6F	SHEET 14 OF 19
DATE 2019-08-16		TITLE	SCALE
		AXIAL PLAY CHECK TOOL	NTS

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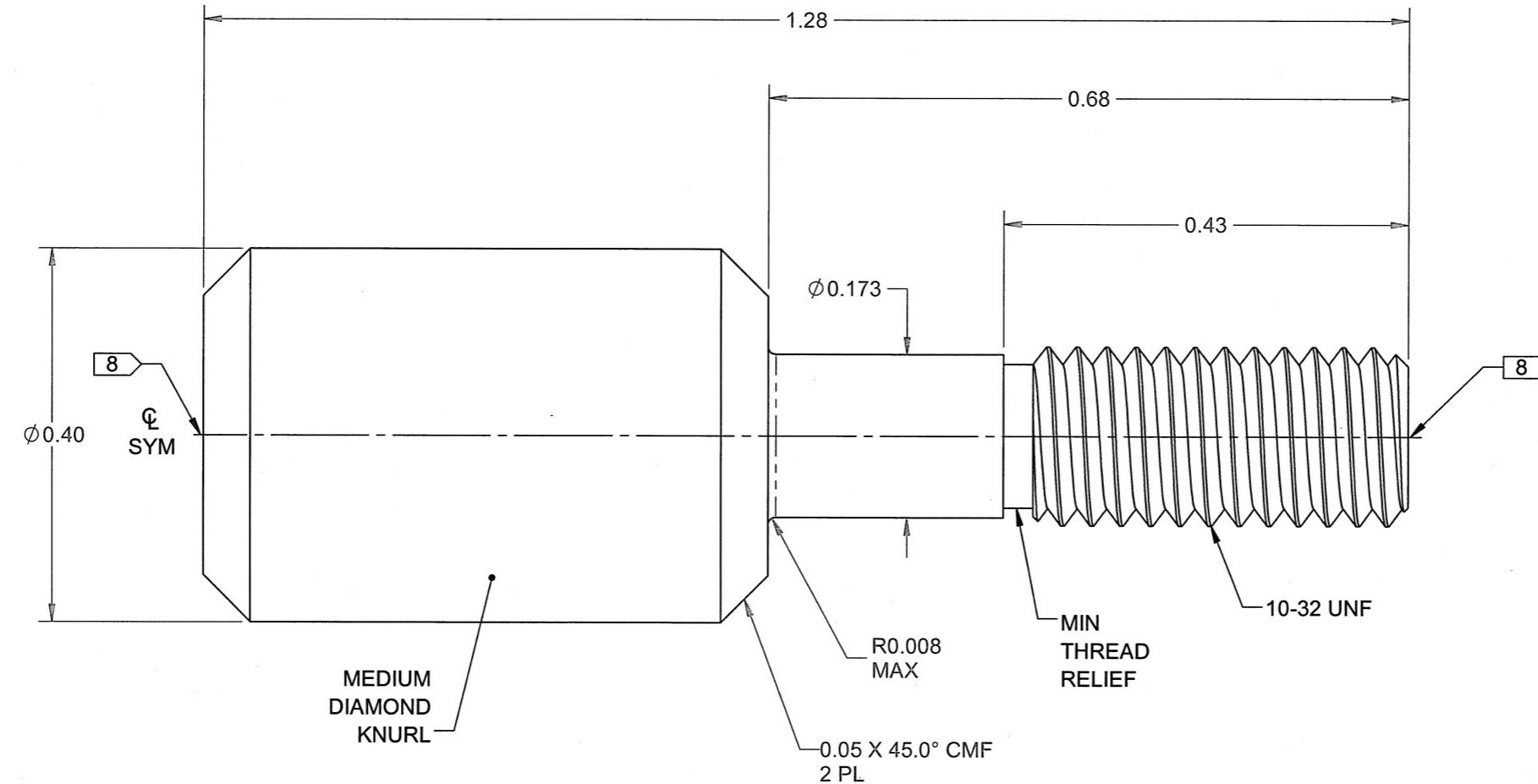
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DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	FK	
APPROVED	WJ	
DATE	2019-08-16	
TOOL PART #	RBW6000G01732-6F	REV. A
TITLE	AXIAL PLAY CHECK TOOL	SHEET 15 OF 19
SCALE	NTS	(+/-)

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RBW6000G01732-6F-14 CLAMP PIN

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	VM VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV. A
APPROVED	VJ	RBW6000G01732-6F	SHEET 16 OF 19
DATE 2019-08-16		TITLE AXIAL PLAY CHECK TOOL	SCALE NTS

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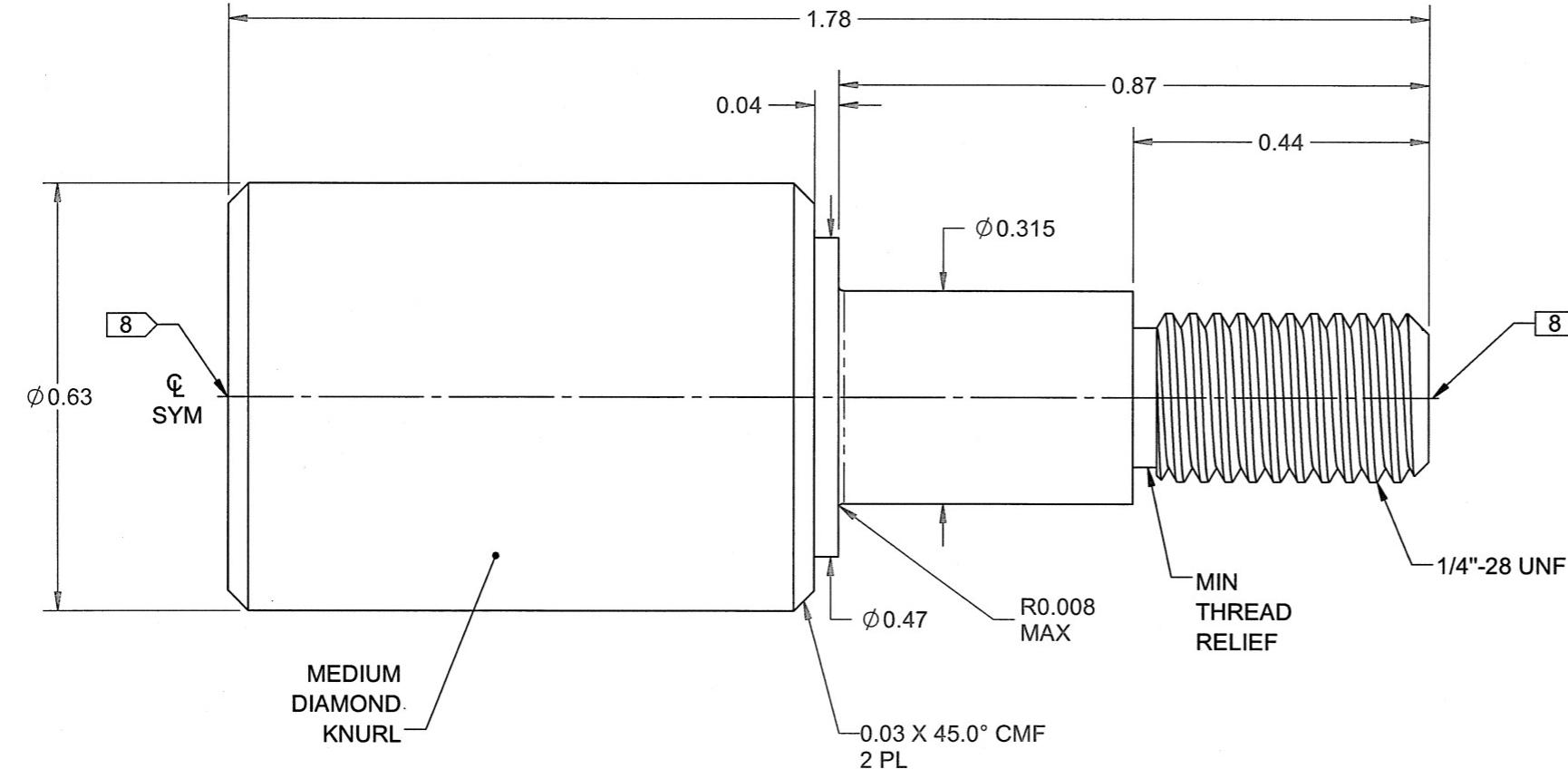
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RBW6000G01732-6F-15 ROTATION CLAMP PIN

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	VM VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	REV. A	
APPROVED	X	TOOL PART # RBW6000G01732-6F	
SHEET 17 OF 19			
TITLE AXIAL PLAY CHECK TOOL			
SCALE NTS			
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DATE 2019-08-16

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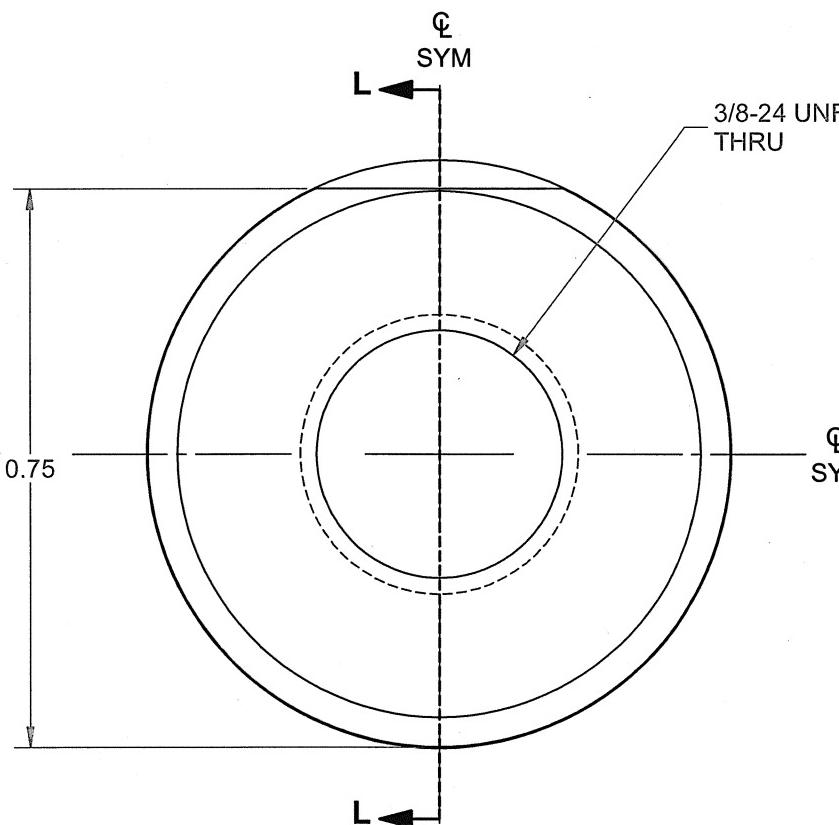
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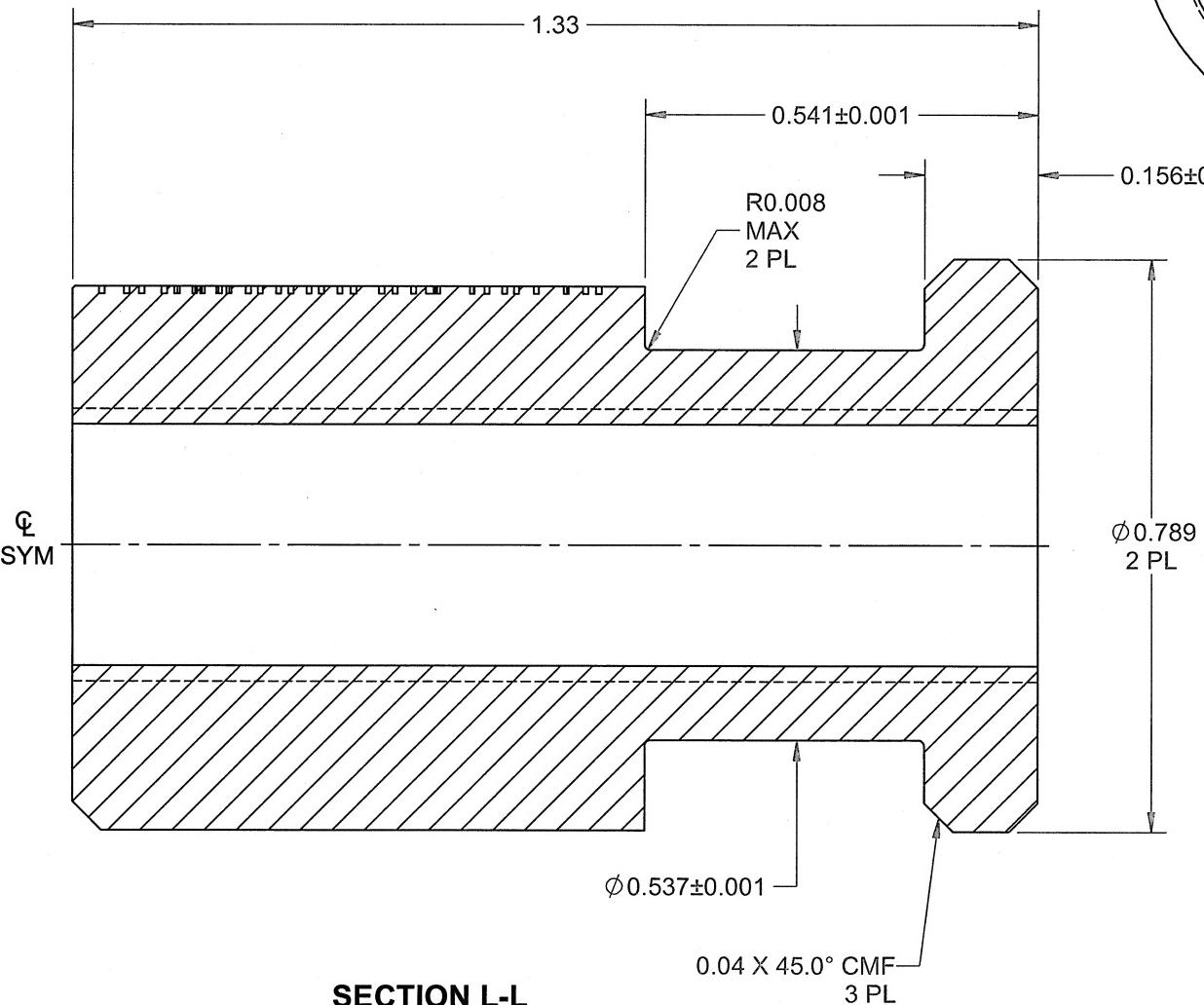
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RBW6000G01732-6F-16 SPACER



SECTION L-L

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 - X.XX = +/- 0.01" / +/- 0.5°
 - X.XXX = +/- 0.005" / +/- 0.1°
 - X.XXXX = +/- 0.0005" / +/- 0.05°
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6000G01732-6F", AS SHOWN

DESIGN DRAWN	VM VM
CHECKED	KPT
MFG. APPR.	FK
APPROVED	<i>WP</i>

DATE 2019-08-16

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RBW6000G01732-6F

REV. A

SHEET 18 OF 19

TITLE
AXIAL PLAY CHECK TOOL

SCALE
NTS

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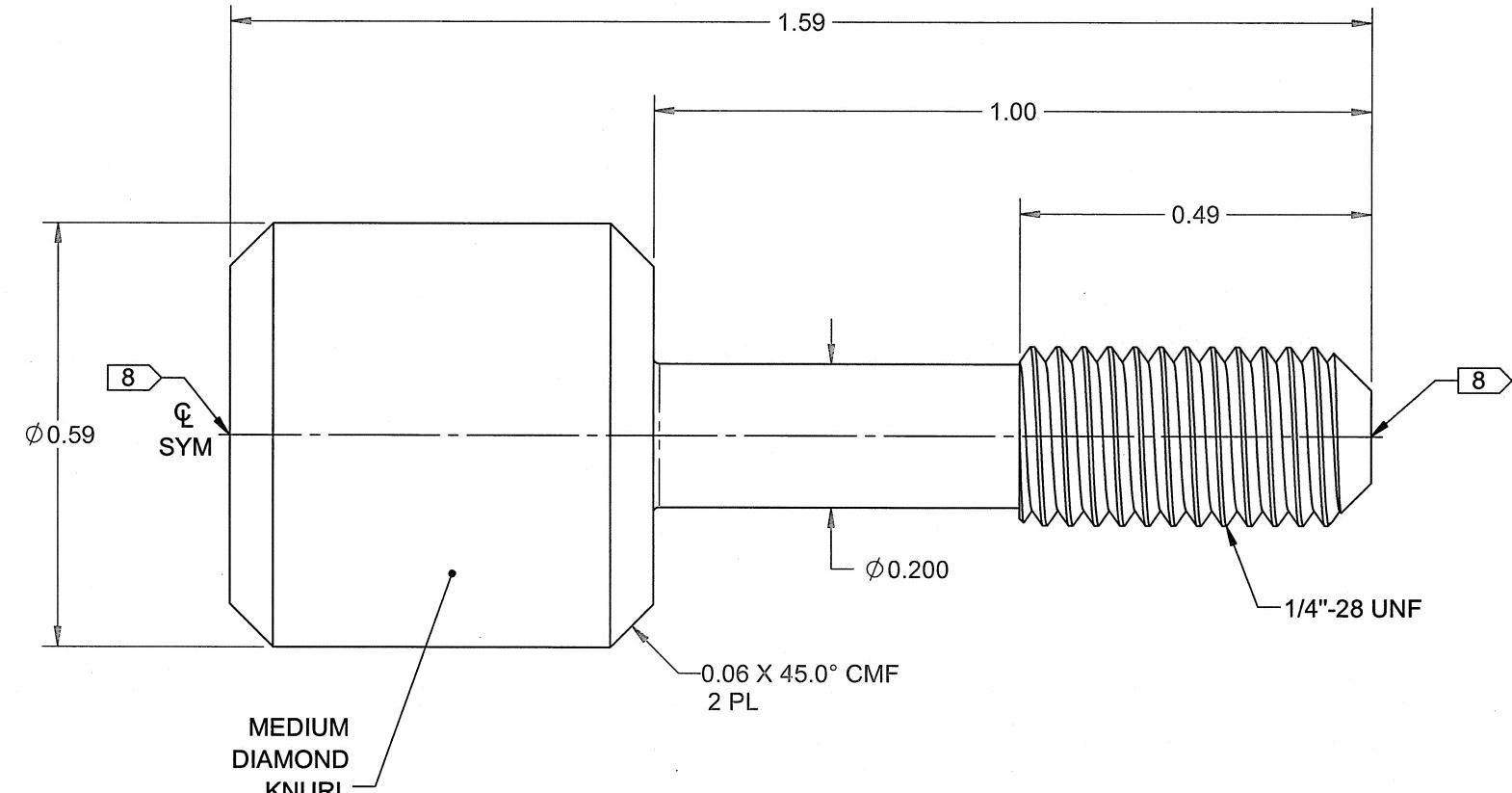
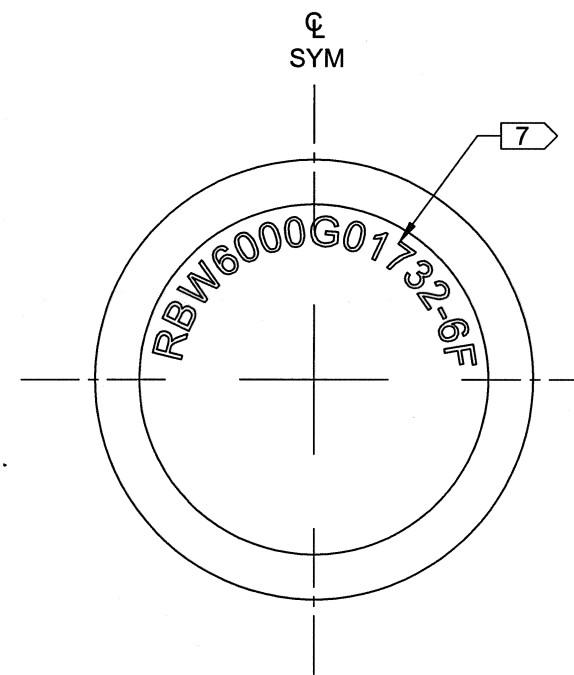
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RBW6000G01732-6F-17 HOLE PIN

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6000G01732-6F", AS SHOWN
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	VJ		
DATE 2019-08-16		REV. A	
TOOL PART # RBW6000G01732-6F		SHEET 19 OF 19	
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS	

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